



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 182365



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Large Fab-5		<i>JS</i>
100	Large Fab	1 pcs	8/31/18	8/31/18	0.00	10.00	Large Fab 1		<i>JS</i>
110	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC9		<i>CPC</i>
120	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC5		<i>CPC</i>
125	HandFinish	1 pcs	8/31/18	8/31/18	0.00	0.29	HandFinish2		<i>D.R. BE-315-10-02</i>
130	Powdercoat	1 pcs	8/31/18	8/31/18	0.00	0.93	Powdercoat2		<i>BR 18-10-2</i>
140	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC3		<i>18-10-4</i>
150	HandFinish	1 pcs	8/31/18	8/31/18	0.00	0.50	HandFinish4		<i>18-10-4</i>
160	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC5		<i>18-10-4</i>
170	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		<i>21 OCT 04 2018</i>
180	QC21-SA	1 Ea	8/31/18	8/31/18	0.00	0.00	QC21		<i>21 OCT 04 2018</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M. 83983 START: 3:35 OUT: 3:50 FINISH 1 3:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>5089833</i>
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5096632</i>
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	<i>5093386</i>
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5096630</i>
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5096633</i>
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	<i>5089677</i>
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	<i>5101540</i>
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	<i>5093147</i>
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	<i>5110912-3</i>
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	<i>5099924</i>
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5101818</i>
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	<i>5097017</i>

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5089804
 5100984
 5106778
 5089950
 5093684
 5089298-1
 506435
 5076007
 5094592
 5103666-1
 5072829

Job Allocations

005787

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	68	0
	D3913-1	1	8	0
	D3913-15	1	13	0
	D3913-3	1	9	0
	D3913-7	2	6	0
	D3913-9	1	13	0
	D3916-041	2	4	0
	D3916-5	3	9	0
	D4016-1	3	12	0
	D4017-7	3	31	0
	D4017-9	2	10	0
	D4020-11	2	11	0
	D4021-1	3	28	0
	D4034-041	1	2	0
	D4034-043	1	1	0
	D4672-1	2	26	0
	M304EX0.75-16F	33	1,615	0
150-HandFinish	AN3-10A	6	133	0
	D2931	2	970	0
	D4021-5	2	32	0
	MS20600-AD4W3	2	231	0
	MS21042L3	6	3,868	0
	NAS1149F0332P	12	1,735	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																				

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S111116
 Part: D3913 - 041
 Job No: 182365
 Serial No/Batch: S1111116
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 09/18/18